

Work Order ID **76859*****76859***

Page 1

November:22-11 10:56:04 AM

Item ID: D3243-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 22/11/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 06/12/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M.C.SDate: 11/11/22 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3243	Rev A								

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B11-12-12

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-12-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76859

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November-22-11 10:56:04 AM

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 Start Date: 22/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 06/12/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		Sw 11/21/13		*6			
150 *150* Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3243	0.00 0.00		SB 11/12/20		5	2		PTD
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sw 11/12/20		5			

W/O: 76859		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3243-04 PAR #: _____ Fault Category: Small FAI's NCR: Yes No DQA: [Signature] Date: 12/01/03
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 12/01/03

NCR: 11-1086		WORK ORDER NON-CONFORMANCE (NCR) J.F.I						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/20	150	1 piece at the forming was out of tolerance at the set up R.C process	S 11/17/20 Q57417	Scrap & destroy	S 11/12/20	S 11/12/20	S 11/12/20 Q57042	S 11/12/20

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Work Order ID 76859

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 Start Date: 22/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 06/12/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Chemical Conversion Coat per QSI005 4.1	0.00							
170									
HandFinish	Memo	0.00							
Hand Finishing									
180		0.00							
180	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Install Inserts as per Dwg D3343								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									

Handwritten signature and date 11-12-21

Handwritten circled number 5

Handwritten signature and date 11/12/21

Handwritten circled number 6

Handwritten date 11/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
-----	---	------	--	--	--	--	--	--	--

200

Powdercoat

Powder Coating

Memo

*****Mask Holes*****

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

210

QC3- Inspect Part Finish

210

QC

Quality Control

Memo

0.00

220

Identify as per dwg & Stock Location: 227

220

Packaging

Packaging

Memo

0.00

6x8 m-l 11/12/21

6 DL 11-12-21

11/12/22 SL(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76859***76859***

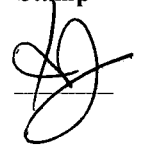
Page 5

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC21 - Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									

11/12/22 MF
11-12-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November-22-11 10:56:08 AM

Page 1

Work Order ID: 76859

76859

Parent Item: D3243-041

D3243-041

Parent Item Name: Bracket Assembly

Start Date: 22/11/2011

Required Date: 06/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			110	sf	163.8656	0.5499	3.473053			

M6061T6S 063

6061-T6.063 Sheet

**

B11-12-12

Location

Loc Qty

Loc Code

MAT021

163.8655684

116308

23.9555684

117285

88.91

119331

51

FE-032-EF

Purchased

No

180

Each

270.0000

4

24

FF-032-EF

Inserts

**

Location

Loc Qty

Loc Code

ST285

270

110836

14

117168

156

117226

100

116-308

EP 11/12/21

2420

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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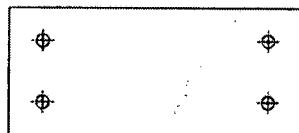
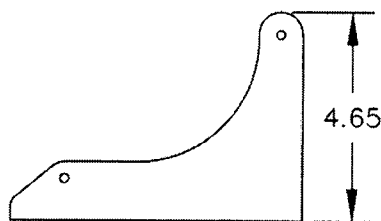
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09	TITLE BRACKET		SCALE 1:2
A	04.01.09	NEW ISSUE	



D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

RELEASED
04.02.03

INSTALL
FE-032-EF INSERTS
(4 PLACES)

2.75 $\begin{smallmatrix} +0.030 \\ 0.000 \end{smallmatrix}$

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76859 M.L.J

11.11/22 11.920
11.420

Ø0.201
(TYP 4
PLACES)

Ø0.290
(TYP 4
PLACES)

GRAIN
DIRECTION

8.581
8.206
7.706
4.214
R0.25 (TYP)
3.339
R0.38 (TYP)
5.494

1.375
5.273
3.714

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

D3243-1
FLAT PATTERN

R0.50
(TYP)

R2.75
(TYP)

0.500
0.000

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